



Dart Aerospace Ltd.
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647.1402

Job Sheet 204949



Part No: 647.1402

Job Qty: 1 pcs

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 12/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.1400 REV E IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1		12/14/20	0.00	0.00	Packaging 1 - 1		
		pcs					Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



Container No: S244370



Part: 647.1402

Job No: 204949

Serial No/Batch: S244370

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/02/20

DAS
41 JAN 03 2020
9:59

Plex 12/23/19 1:27 PM Dart.lajeunesse.marie

120 Small Fab - 2 - B4B	1 pcs	12/14/20	0.00 0.50	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				Packaging 1 - 37	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	DAS
				Small Fab - 6 - B4B	41 JAN 03 2020
				Small Fab - 7 - B4B	9-89
130 QC 5	1 pcs	12/14/20	0.00 0.00	Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
140 Packaging 3-1 - Stock - B4B	1 ✓ pcs	12/14/20	0.00 0.00	QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	JAN 03 2020 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	DAS
				Packaging 3 - 4 - B4B	cc048 80
				Packaging 3 - 5 - B4B	JAN 07 2020 9-89
				Packaging 3 - 6 - B4B	JAN 07 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
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				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	1	12/14/20	0.00 0.00	QC 21 - SA - 21 ✓	CCK 088
	pcs			QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE

598: 5241075 exp. date: 1/21

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - (QC21- Final Inspection - Work Order Release)

JAN 07 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9701	Cutter Sub Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5232606
647.1501	Lower Deflector Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5232529
MS21042L08	Nut	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5232687
MS27039-08-19	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5231293
NAS1149FN832P	Washer (AN960-8)	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5224538

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.9701	1	3	0
	647.1501	1	1	0
	MS21042L08	3	794	0
	MS27039-08-19	3	842	0
	NAS1149FN832P	6	1,652	0

Part Specifications

Specifications could not be found.

Plex 12/23/19 1:27 PM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	DEPARTMENT/PROCESS	MRB (QSI042)
Date : _____		Sequence #: _____	
Description Work Order Deviation		Disposition	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
		QTY Affected : _____	
		Other/Details: _____	